

Date: Friday, 09/05/2008 1:49:10 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOOR ASSEMBLY
Job Number : 39169A	
Estimate Number : 11454	
P.O. Number :	Part Number : D41269401
This Issue : 09/05/2008 S.O. No. :	Drawing Number : D412-694
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C1
Previous Run : 36652A	Material :
Written By :	Due Date : 15/06/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 08.5.09</u>	
Comment :	
Est Rev: A 05.12.09 New Issue KJ/RF	
Est Rev: B 06.04.18 New dwg rev. ecn781 EC	
Est Rev: C 06.07.11 Revised per B24660 KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL

**Comment:** DOCUMENT CONTROL

Issue red decal labels for D412-694-01

CHG005

2.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY

**Comment:** COMPOSITE ASSEMBLY

D412-694-01 Drill Process

1- Drill (7) holes using Ø(#40) drill. Drill (3) holes top/bottom Ø(#40) for insert (do not pass thru) using B30-23000-01 as per Dwg D412-694 page 4 (view P).

AO 080623

2- Open (1) hole to 11/16" (0.688) for the handle using unibit. Transfer (4) Ø(#30) holes from D3151-041 to the door and c'sink from far side for the rivet. Transfer (2) holes Ø(3/16") for MS24694-C5 screw as per Dwg D412-694 page 4 (view P).

Note: D3151-041 orientation in the door.

AO 080623

3- Open (3) holes Ø(#19) or (0.166) top/bottom of the door and c'sink Ø0.300 x 100° from the far side and D3155-041/-042 bracket assembly as per Dwg D412-694 page 4 (view P).

AO 080623

4- Drill Ø(#30) holes using drill Jig D3144-T1 for the doublers. Drill (2) holes in two places Ø 3/16" (0.188) for the slot opening. Router slot using D3144-T2/-T3 as per Dwg D412-694 page 2.

Note: The (12) holes for the (6) nut plates can not be less than 0.290" from inside edge.

AO 080623

5- Open (3) holes to Ø37/64" (0.578) at top/bottom insert for D3163-041 cover assembly as per Dwg D412-694 page 4 (view P). Drill Ø(#30) outer door handle as shown in view Z-Z page 2. Open holes to Ø0.257.

AO 080623

6- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-1. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view K, L, M, Q).

AO 080623

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Description :

7- Drill Pilot holes Ø(#1/8") for rollers using drill Jig DT8703-2. Use unibit to open holes to Ø 37/64" (0.578) for inserts as per Dwg D412-694 page 2, page 6 (view H, J). *AS 080623*

8- Drill (27) pilot holes Ø(#30) using drill Jig DT8703-3LH for D3126 brackets as per Dwg D412-694 page 2 (view G-G). Use unibit to open holes Ø37/64" (0.578) for inserts. *AS 080623*

9- Drill (2) Pilot holes Ø(#30) by transfer from D3152-041 bracket. Use unibit to open holes to Ø37/64" (0.578) for inserts as per Dwg D412-694 page 6 (view Q). *AS 080623*

10- Drill (12) Ø(#30) holes from the edge of the door to opposite side for D3162-041 bracket using a long drill and keep drill perpendicular. Ensure (4) holes used from the center of the hole to top and bottom edge of the thick section of D3163-041 cover assembly. Compare hole depth with rivet in the foam as per Dwg D412-694 page 4 (view P) and (view R-R/-S-S). Drill (8) Ø(#30) holes from the edge of the door using a long drill and keep drill perpendicular. About the (4) last holes around the small square of the cover, take the measurement 0.250" from each corner of the D3163-041 cover. *AS 080623*

3.0

8000528

Insert



Comment: Qty.: 55.0000 Each(s)/Unit Total : 55.0000 Each(s)

Insert

M19443

AS

080623

Batch

A/R Hysol EA934NA

M107007

Expiry Date:

09 01 31

4.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1-Install inserts as per Dwg D412-694 page 2 (view G-G); page 6 (view H, J, L, M, Q)

2- Sand flush excess Hysol around the insert on both doors. *AS 080625*

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect that inserts are flush with the surface. *20807-10*

6.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1. Apply Primer filler and reducer around the inserts on both doors.

A/R 11045

Primer Filler

Batch:

108707/106803

A/R 12375S

Reducer

Batch:

105936

AS

08-07-10

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Machine Or Operation:

Description :

7.0

QES

INSPECT WORK TO CURRENT STEP

QC14



08-07-21 (1)



Comment: INSPECT WORK TO CURRENT STEP

8.0

D31105

Handle Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle

Batch:

B27081

JS

08/05/12

(XU)

9.0

D31151

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket

Batch:

30152

JS

08/05/12

(XU)

10.0

D31167

Seal



Comment: Qty.: 5.6666 f(s)/Unit Total: 5.6666 f(s)

Seal ZX2054

Batch:

B27239

JS

08/05/12

(XU)

11.0

D31169

Seal



Comment: Qty.: 6.4166 f(s)/Unit Total: 6.4166 f(s)

Seal ZX1267

Batch:

17463

JS

08/05/12

(XU)

12.0

D3121041

Bracket Assembly



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Bracket Assembly

Batch:

B337182
B36727

JS

08/05/12

(XU)

13.0

D3121043

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Batch:

24699

JS

08/08/12

(XU)

Dart Aerospace Ltd

WIO: 319169A		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/07/21	7.0	QC 14 required for Paint/Primer inspection Est # 11454 perm. Change					

Part No: 0412-694-01 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D31221

Lever



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lever

Batch

25539

JS 08/05/12 (X)

15.0

D31231

Cam



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Cam

Batch

1053617

JS 08/05/12 (X)

16.0

D31241

Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Hook

Batch

1053617

JS 08/05/12 (X)

17.0

D31242

Hook



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Hook

Batch

1053617

JS 08/05/12 (X)

18.0

D31261

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket

Batch

11053617

* THIS IS written on it. dot in comp

JS 08/05/12 (X)

19.0

D31263

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket

Batch

148657

JS 08/05/12 (X)

20.0

D31265

Bracket



Comment: Qty.: 5.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bracket

Batch

11053617

JS 08/05/12 (X)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D3132041

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

M10530-17

JS 08/05/12 (X)

22.0

D3133042

Rod Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Rod Weldment

Batch

M10536-17

JS 08/05/12 (X)

23.0

D3135041

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch

30730

JS 08/05/12 (X)

24.0

D3137045

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BRACKET ASSEMBLY

Batch

B27239

JS 08/05/12 (X)

25.0

D31381

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cover

Batch

~~B18863~~ B39184

JS 080721

26.0

D31391

Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch

B18863

Batch not in comp

JS 08/05/12 (X)

27.0

D31393

Guard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Guard

Batch

24781

Batches are wrong in comp. They should be switched

JS 08/05/12 (X)

W/O:		WORK ORDER CHANGES					
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Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D314005

Door



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Door Kit

Batch

39169A

AS 080520

29.0

D31411

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring #204-032-734-001

Batch

3472x

AS 08/05/12

(XU)

30.0

D31443

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

18816

AS 08/05/12

(XU)

31.0

D314413

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

221 B21911

AS 08/05/12

(XU)

32.0

D3144109

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

B23145

AS 08/05/12

(XU)

33.0

D3144111

Doubler



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Doubler

Batch

27380

AS 08/05/12

(XU)

34.0

D31481

Clevis



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clevis

Batch

10536-12

AS -08/05/12

(XU)

W/O:		WORK ORDER CHANGES					
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Job Number: 39169A

Part Number: D41269401

Job Number:



Seq. #:	Machine Or Operation:	Description :
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35.0	D3151041	Doubler Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Doubler Assembly
Batch 24685

AS 08/05/12 (X1)

36.0	D3152041	Bracket Assembly
------	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch 18867

AS 08/05/12 (X1)

37.0	D3155041	Bracket Assembly
------	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch 27178

AS 08/05/12 (X1)

38.0	D3155042	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch B26433

AS 08/05/12 (X1)

39.0	D31561	Bracket
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bracket
Batch 24772

AS 08/05/12 (X1)

40.0	D3162041	Bracket Assembly
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Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Bracket Assembly
Batch B37158

AS 08/05/12 (X1)

41.0	D3162043	Bracket Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bracket Assembly
Batch 36949

AS 08/05/12 (X1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

D3162044

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Batch

310734

AS 08/05/12 (XU)

43.0

D3163041

Cover Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Cover Assembly

Batch

07836

AS 08/05/12 (XU)

44.0

D3183041

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bracket Assembly

Batch

B36735

AS 08/05/12 (XU)

45.0

D32031

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle

Batch

B30158A

AS 08/05/12 (XU)

46.0

D33081

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Doubler

Batch

B39187
B21912

AS 08/05/12 (XU)

47.0

AN52510R6

Screw



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Screw

Batch

M15943

AS 08/05/12 (XU)

48.0

AN52510R7

Screw



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

Screw

Batch

M106166

AS 08/05/12 (XU)

W/O:		WORK ORDER CHANGES					
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Seq. #:

Machine Or Operation:

Description :

49.0

AN960JD8

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Washer

Batch

M167091

AS 08/05/12 (XU)

50.0

AN960JD10L

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Washer

Batch

M104885

AS 08/05/12 (XU)

51.0

AN960JD10LL

Washer



Comment: Qty.: 15.0000 Each(s)/Unit Total: 15.0000 Each(s)

Washer

Batch

M19600

AS 08/05/12 (XU)

52.0

AN960JD416L

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Washer

Batch

M107008

AS 08/05/12 (XU)

53.0

BSP45

Commercial Rivet



Comment: Qty.: 79.0000 Each(s)/Unit Total: 79.0000 Each(s)

Commercial Rivet

Batch

M106937

AS 08/05/12 (XU)

54.0

BSP46

Commercial rivet



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Commercial rivet

Batch

M101237

AS 08/05/12 (XU)

55.0

M7885243

Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Rivet

Batch

M107370

AS 08/05/12 (XU)

W/O:		WORK ORDER CHANGES					
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Machine Or Operation:

Description :

56.0

M7885344

Rivets



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Rivets

Batch

M19099

AS 08/05/12 (XU)

57.0

MS203922C9

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M11784

AS 08/05/12 (XU)

58.0

MS203922C17

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M18949

AS 08/05/12 (XU)

59.0

MS203923C21

Pin



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch

M104156

AS 08/05/12 (XU)

60.0

MS20426AD33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Rivet

Batch

M1563

AS 08/05/12 (XU)

61.0

MS20426AD45

Rivet



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Rivet

Batch

M3459

AS 08/05/12 (XU)

62.0

CR3212404

Cherry Rivet



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rivet

Batch

M17715 x8 M107862 x8

AS 08/05/12 (XU)

Dart Aerospace Ltd

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Seq. #:

Machine Or Operation:

Description :

63.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nut

Batch

M106051

AS 08/05/12 (X)

64.0

MS21042L08

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

Batch

M167423

AS 08/05/12 (X)

65.0

MS21072L3

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Nutplate

Batch

M167003

AS 08/05/12 (X)

66.0

MS24665151

Cotter Pin



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Cotter Pin

Batch

M14526

AS 08/05/12 (X)

67.0

MS24693S271

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

Batch

M14478

AS 08/05/12 (X)

68.0

MS24694C5

Screw



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Screw

Batch

M106815

AS 08/05/12 (X)

69.0

MS24694S5

Screw



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Screw

Batch

~~M12410~~ M18949

AS 08/05/12 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:49:10 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169A

Part Number: D41269401

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

70.0	MS24694S50	Screw
------	------------	-------



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)
Screw
Batch M107393

AS 08/05/12 (X)

71.0	MS24694S98	Screw
------	------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw
Batch M107534

AS 08/05/12 (X)

72.0	MS27039105	Screw
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
Batch M3501

AS 08/05/12 (X)

73.0	MS27039106	Screw
------	------------	-------



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)
Screw
Batch M106815

AS 08/05/12 (X)

74.0	MS27039108	Screw
------	------------	-------



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)
Screw
Batch M106589

AS 08/05/12 (X)

75.0	MS35275233	Screw
------	------------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Screw
Batch 11822

AS 08/05/12 (X)

76.0	MS35649264	Nut
------	------------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
Batch M11822

AS 08/05/12 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:49:10 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

77.0

MS356503252

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch

M11735

JS 08/05/12 (X)

78.0

MS518597

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch

M100421

JS 08/05/12 (X)

79.0

NAS43DD310

Spacer



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Spacer

Batch

M19347

JS 08/05/12 (X)

80.0

NAS43DD314

Spacer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Spacer

Batch

M19347

JS 08/05/12 (X)

81.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Assembly Process

1- Install D3162-041 as per Dwg D412-694 page 4 (view R-R/S-S) and D3156-1 bracket as per (view T-T/U-U). Open holes to #30 (0.128) for rivet and alodine the open holes.

Note: Start installation window side. Wait to fix D3162-041/-043.

JS 080721

2- Install D3151-041 Doubler as per Dwg D412-694 page 4 (view P).

JS 080721

3- Connect D3132-041 Rod Weldment with D3122-1 Lever and D3133-041 Rod Weldment as per Dwg D412-694 page 4 (view P).

JS 080721

4- Assemble D3123-1 Cam with D3124-1/-2 Hook with D3155-041/-042 Bracket Assembly as per Dwg D412-694 page 4 (view P).

JS 080721

5- Install D3203-1 handle with D3308-1 doubler as per Dwg D412-694 page 2 (view Z-Z).

JS 080721

6- Install D3155-041/-042 Bracket Assembly and D3110-5 Handle as per Dwg D412-694 page 4 (view P) and

JS 080721

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:49:10 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

page 2. Adjust rod weldment until everything works properly and looks in place.

82.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

83.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

D412-694-01 Assembly Process (Continued)

1- Install D3116-7-0680 Seal and doublers. Transfer slot opening in the seal as per Dwg D412-694 page 2 (view V-V and N).

Note: If this is the D412-694-013, wait until the VIP trim is fixed on the door.

080722

2- Install D3110-5 Handle Assembly in the D3163-041 Cover Assembly. Ensure Handle works freely. Ensure D3163-041 cover assembly is aligned with the door edge on both sides and D3110-5 Handle works properly.

PTO →

080722

3- Transfer the holes to the cover with the hole finder. EXCEPTION: the (4) holes around the handle. Install the bracket with the holes from the small square of the cover (Ø0.250")

080722

4- Open 15/64" (0.234) holes to D3163-041 cover assembly and D3135-041 handle weldment. Transfer D3139-1/-3 guard holes in cover assembly and drill holes for nutplate. Deburr and touch up holes with alodine as per Dwg D412-694 page 2.

080722
080722

5- Install MS21072-L3 Nutplate and Guard as per Dwg D412-694 page 2.

6- Transfer (#30) holes from D3144-13 doubler to seal and door. Ensure D3116-9-0770 is properly aligned as per Dwg D412-694 page 2 (section NN-NN). Apply 732 RTV Clear (A/R) in the hole prior to installing rivet and then in the rivet head after installation.

A/R RTV732 Clear Batch: M108657 Expiry Date: 09/09/17

080723

7- Install D3126 Brackets and D3138-1 Cover as per Dwg D412-694 page 2 (view G-G and NN-NN).

080723

8- Install and assemble brackets as per Dwg D412-694 page 2 and 5 (view H, J, L, M and Q).

080723

84.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP





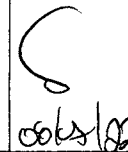


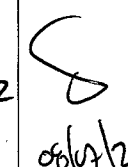
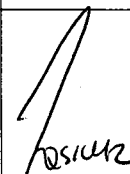
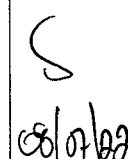
Install door on mock up helicopter to insure proper fit and function

080724

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-694-01 PAR #: N/A Fault Category: Tech Support NCR: (Yes) No DQA: D Date: 08/08/07
 QA: N/C Closed: D Date: 08/08/08

NCR: 39169A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
080722	83.	D3163-041 during drilling holes to .250, it was noticed when installing handle D310-5 Holes did not		Scrap D3163-041 327836 Replace w/same P/N and Batch QTY x 1	 080722	 08/07/02		 08/07/02
		Line up to Space Door R/C D3163-041 was drilled incorrectly human error			 080722	 08/07/02		 08/07/02

NOTE: Date & initial all entries

Date: Friday, 09/05/2008 1:49:10 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOOR ASSEMBLY

Job Number: 39169A

Part Number: D41269401

Job Number:



Seq. #:

Machine Or Operation:

Description :

85.0

COMPOSITE ASSY

COMPOSITE ASSEMBLY



Comment: COMPOSITE ASSEMBLY

1- Finish installing D3163-041 in the door.

2- Install red decal before closing cover.

AD

080724

86.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0807-240

87.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

88P 39169

u

08/08/25

88.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/25

Job Completion



u 08/08/25

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
X				D412-694-01	DOOR ASSEMBLY
	X			D412-694-02	DOOR ASSEMBLY
		X		D412-694-03	DOOR ASSEMBLY
			X	D412-694-04	DOOR ASSEMBLY
		1	1	D3110-1	ESCUTOHEON
		1	1	D3110-3	HANDLE
1	1			D3110-5	HANDLE ASSEMBLY
		1	1	D3111-041	PLATE ASSEMBLY
		2	2	D3112-1	GUIDE
		1	1	D3113-1	SPRING
		1	1	D3114-1	PIVOT
1	1			D3115-1	BRACKET
		1	1	D3116-11-0180	SEAL
		1	1	D3116-5-0680	SEAL
1	1			D3116-7-0680	SEAL
1	1			D3116-9-0770	SEAL
		1		D3119-041	COVER ASSEMBLY
		1		D3119-042	COVER ASSEMBLY
		1		D3120-1	COVER
		1		D3120-2	COVER
		1		D3120-3	COVER
		1		D3120-4	COVER
3	3			D3121-041	BRACKET ASSEMBLY (ROLLER)
1				D3121-043	BRACKET ASSEMBLY (ROLLER)
		1		D3121-044	BRACKET ASSEMBLY (ROLLER)
1	1			D3122-1	LEVER
2	2			D3123-1	CAM
1	1			D3124-1	HOCK
1	1			D3124-2	HOCK
		1	1	D3125-1	LEVER
		1	1	D3125-3	LEVER
		1	1	D3125-5	LEVER
		1	1	D3125-7	LEVER
1	1			D3126-1	BRACKET (SLIDER)
1	1			D3126-3	BRACKET (SLIDER)
5	5			D3126-5	BRACKET (SLIDER)
1	1			D3127-1	SPACER
		1	1	D3128-1	SHIM
		2	2	D3129-1	LEVER
		2	2	D3130-1	CLEVIS BASE
		1	1	D3131-1	STOP
1				D3132-041	ROD WELDMENT
	1			D3132-042	ROD WELDMENT
	1			D3133-041	ROD WELDMENT
1				D3133-042	ROD WELDMENT
		1	1	D3134-1	ROD
		1	1	D3134-3	ROD
1	1			D3135-041	HANDLE WELDMENT
1	1			D3137-045	BRACKET ASSEMBLY
1				D3138-1	COVER
	1			D3138-2	COVER
1	1			D3139-1	GUARD
1				D3139-3	GUARD
	1			D3139-4	GUARD
1				D3140-05	DOOR
	1			D3140-06	DOOR
		1		D3140-07	DOOR
			1	D3140-08	DOOR
2	2			D3141-1	SPRING
		1	1	D3143-1	CLEVIS
		3	3	D3143-3	CLEVIS
		1		D3144-1	DOUBLER
1				D3144-3	DOUBLER
	1			D3144-105	DOUBLER
	1			D3144-107	DOUBLER
1				D3144-109	DOUBLER

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
1	1			D3144-111	DOUBLER
	1			D3144-115	DOUBLER
		1		D3144-117	DOUBLER
		1		D3144-121	DOUBLER
		1		D3144-119	DOUBLER
	1			D3144-123	DOUBLER
1	1			D3144-13	DOUBLER
		1		D3145-1	HINGE BRACKET
		1		D3145-2	HINGE BRACKET
		1		D3146-1	HINGE BRACKET
		1		D3146-2	HINGE BRACKET
		2	2	D3147-1	PIN
2	2			D3148-1	CLEVIS
		2	2	D3149-1	STRIKER PLATE
		2	2	D3150-1	GUIDE
1	1			D3151-041	DOUBLER ASSEMBLY
1				D3152-041	BRACKET ASSEMBLY
	1			D3152-042	BRACKET ASSEMBLY
		1	1	D3154-1	KEY
1	1			D3155-041	BRACKET ASSEMBLY
1	1			D3155-042	BRACKET ASSEMBLY
2	2			D3156-1	BRACKET
		2	2	D3157-1	SPACER
		3	3	D3159-041	BRACKET ASSEMBLY
		1		D3159-043	BRACKET ASSEMBLY
			1	D3159-044	BRACKET ASSEMBLY
10	10			D3162-041	BRACKET ASSEMBLY
1		1		D3162-043	BRACKET ASSEMBLY
1		1		D3162-044	BRACKET ASSEMBLY
1				D3163-041	COVER ASSEMBLY
	1			D3163-042	COVER ASSEMBLY
1				D3183-041	BRACKET ASSEMBLY (ROLLER)
	1			D3183-042	BRACKET ASSEMBLY (ROLLER)
1	1			D3203-1	HANDLE ASSEMBLY
2	2			D3308-1	DOUBLER
55	55	21	21	80-005-2-8	INSERT (OR SL2052-3-4)
10	10			AN625-10R6	SCREW
8	8	4	4	AN625-10R7	SCREW
		8	8	AN660-ID10	WASHER
18	18	4	4	AN660-ID10L	WASHER
13	13	32	32	AN660-ID10LL	WASHER
6	6			AN660-ID16L	WASHER
		4	4	AN660-ID6L	WASHER
6	6			AN660-ID8	WASHER
		2	2	AN660-ID8L	WASHER
		2	2	AN660-ID8LL	WASHER
		10	10	ASL4-632-80	INSERT
87	87	50	50	BSP45	RIVET
		12	12	FVW10-032	WASHER
		6	6	FVW10-032	WASHER
12	12			M7885-24	RIVET (OR CR3213-4-3)
		3	3	M7885-34	RIVET (OR CR3212-4-3)
		2	2	MS20392-1C11	PIN
		7	7	MS20392-2C15	PIN
2	2			MS20392-2C17	PIN
2	2	2	2	MS20392-2C9	PIN
2	2			MS20392-3C21	PIN
8	8			MS20426AD3	RIVET
12	12			M7885/3-4	RIVET
8	8			MS20426AD4	RIVET

Qty -01	Qty -02	Qty -03	Qty -04	Part Number	Description
20	20			MS20426AD4	RIVET
		6	6	MS21042L06	NUT
6	6	2	2	MS21042L08	NUT
		5	5	MS21042L3	NUT
4	4			MS21042L4	NUT
4	4			MS21072L3	NUTPLATE
6	6	9	9	MS24665-151	COTTER PIN
4	4			MS24683-S271	SCREW
		2	2	MS24694-C4	SCREW
4	4			MS24694-C5	SCREW
6	6			MS24694-S6	SCREW
18	18			MS24694-S60	SCREW
		4	4	MS24694-S66	SCREW
		2	2	MS24694-S63	SCREW
		4	4	MS24694-S80	SCREW
4	4			MS24694-S98	SCREW
		2	2	MS25281-R6	CLAMP
2	2	2	2	MS27039-1-05	SCREW
14	14	12	12	MS27039-1-06	SCREW
13	13	6	6	MS27039-1-08	SCREW
		2	2	MS35205-231	SCREW
2	2			MS35275-233	SCREW
2	2			MS35649-264	NUT
		4	4	MS35650-305T	NUT
2	2			MS35650-3252	NUT
2	2	3	3	MS51859-7	WASHER
		4	4	NAS1169-10L	WASHER
		14	14	NAS388-6-8P	SCREW
		15	15	NAS391B5P	WASHER
7	7			NAS430D3-10	SPACER
6	6			NAS430D3-14	SPACER
		2	2	NAS430D3-40	SPACER

GENERAL NOTES:

- FOR ADJUSTMENT OF LOCKING MECHANISM PRIOR TO DOOR ASSEMBLY, SET AT UNLATCH POSITION AND ADJUST SCREW INWARD UNTIL D3124-1/2 HOOK RESTS AGAINST CUTOUT SHOWN IN VIEW N.
- IF REQUIRED, NOTCH D3125-1 LEVER (REF) TO CLEAR THE D3130-1 CLEVIS BASE (REF, 2 PLACES) TO ALLOW FOR FULL TRAVEL OF THE LEVER.
- HOLES AND PARTS TO BE LOCATED PER DRILLING JIGS, E30-23000-01; D3144-T1/-T2/-T3; D31703-3; D3162-041T1 (FOR -01 DOOR ASSY); E30-23000-02; D3144-T7/-T8/-T9; D31703-9; D3162-041T2 (FOR -02 DOOR ASSY); D3144-T4/-T5/-T6; D3119-041T1; D3112-T1/-T2 (FOR -03 DOOR ASSY); D3144-T10/-T11/-T12; D3119-042T1; D3112-T1/-T2 (FOR -04 DOOR ASSY).
- INSTALL INSERTS PER DART QSI 006. LOCATE TO MATCH HOLE PATTERN OF MATING PARTS.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES.
- IDENTIFY D412-694-01/-02/-03/-04 DOOR ASSEMBLIES USING D2729-1 DECALS.

CI	06.03.28	ADD OPTION M7885/3-4
C	05.11.23	ADD D3137-045, D3162-043/-044; REMOVE D3137-041; UPDATED NOTES
B	04.10.07	UPDATE DRAWING
A	02.05.21	NEW ISSUE
DESIGN	CP	DRAWN BY RF
CHECKED	#	APPROVED #
DATE	05.11.23	TITLE DOOR ASSEMBLY
DART	DART AEROSPACE LTD.	HAWKESBURY, ONTARIO, CANADA
DRAWING NO.	D412-694	REV. C
SHEET 1 OF 6		SCALE NTS

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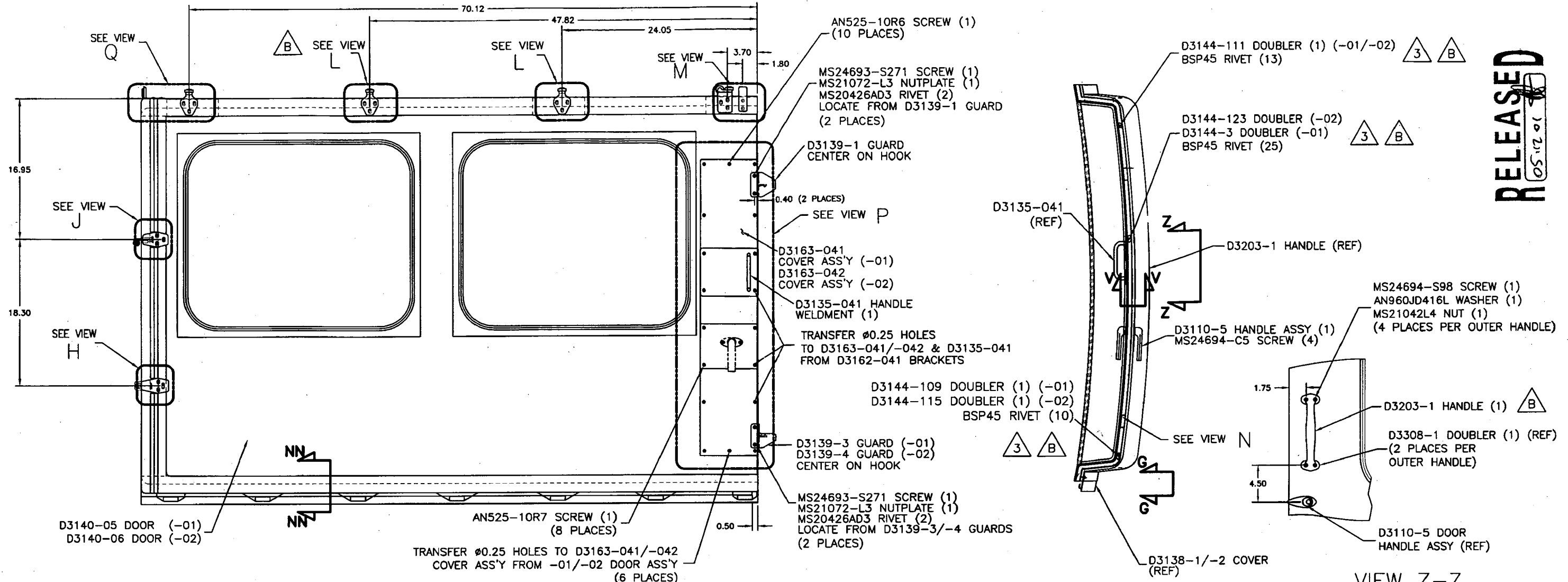
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05.12.01-#

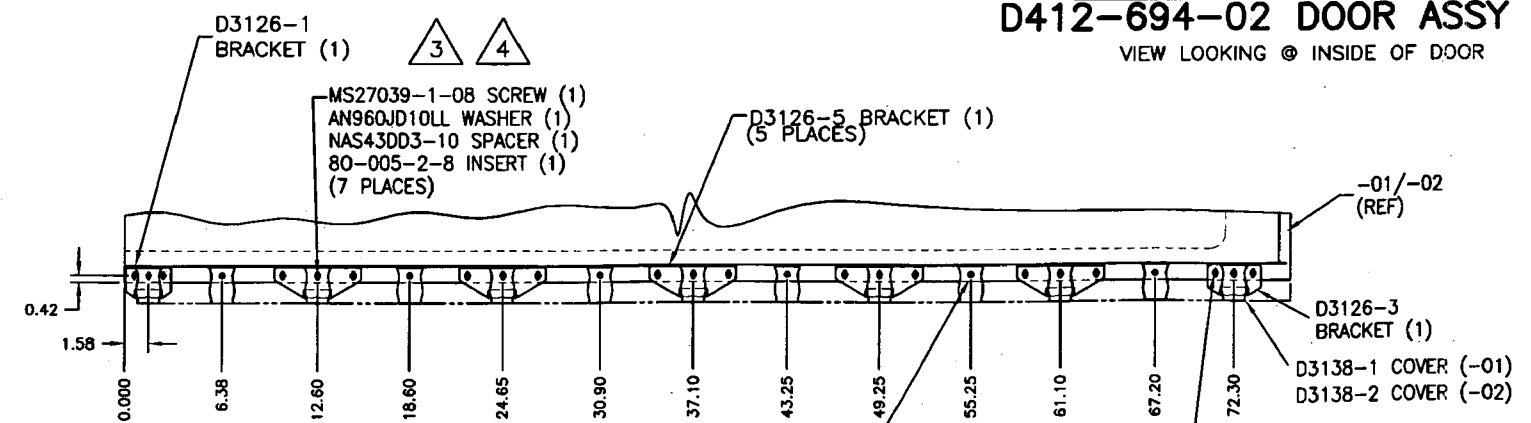
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05-12-01



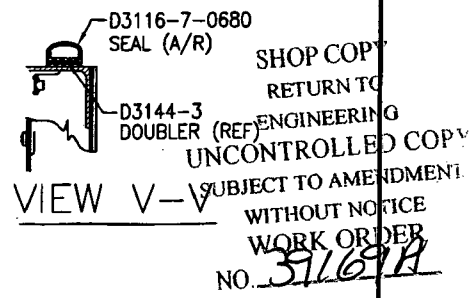
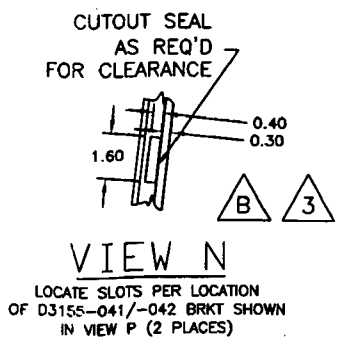
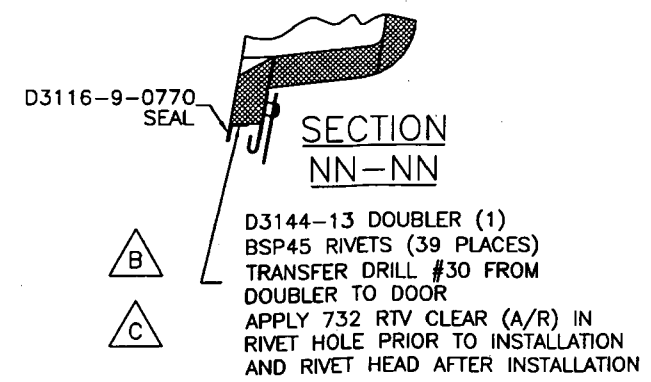
D412-694-01 DOOR ASSY (SHOWN)
D412-694-02 DOOR ASSY (OPP.)
 VIEW LOOKING @ INSIDE OF DOOR

VIEW Z-Z
OUTER DOOR HANDLE INSTALLATION



VIEW G-G
 (D3138-1/-2 SHOWN IN SECTIONS FOR CLARITY OF HDWR LOCATIONS)

- MS27039-1-08 SCREW (1)
- AN960JD10LL WASHER (1)
- NAS43DD3-14 SPACER (1)
- 80-005-2-8 INSERT (1)
- (6 PLACES)
- MS27039-1-06 SCREW (2)
- AN960JD10L WASHER (2)
- 80-005-2-8 INSERT (2)
- (7 PLACES)



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		CHECKED	APPROVED	D412-694	SHEET 2 OF 6
		DATE		TITLE	SCALE
		05.11.23		DOOR ASSEMBLY	NTS

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 WITHOUT NOTICE
 WORK ORDER
 NO. 3167A

RELEASED
05-12-21

D3146-1 HINGE BRACKET (-03)
D3146-2 HINGE BRACKET (-04)

MS27039-1-08 SCREW (1)
80-005-2-8 INSERT (1)
AN960JD10LL WASHER (1)
(3 PLACES)

4

D3145-1 HINGE BRACKET (-03)
D3145-2 HINGE BRACKET (-04)

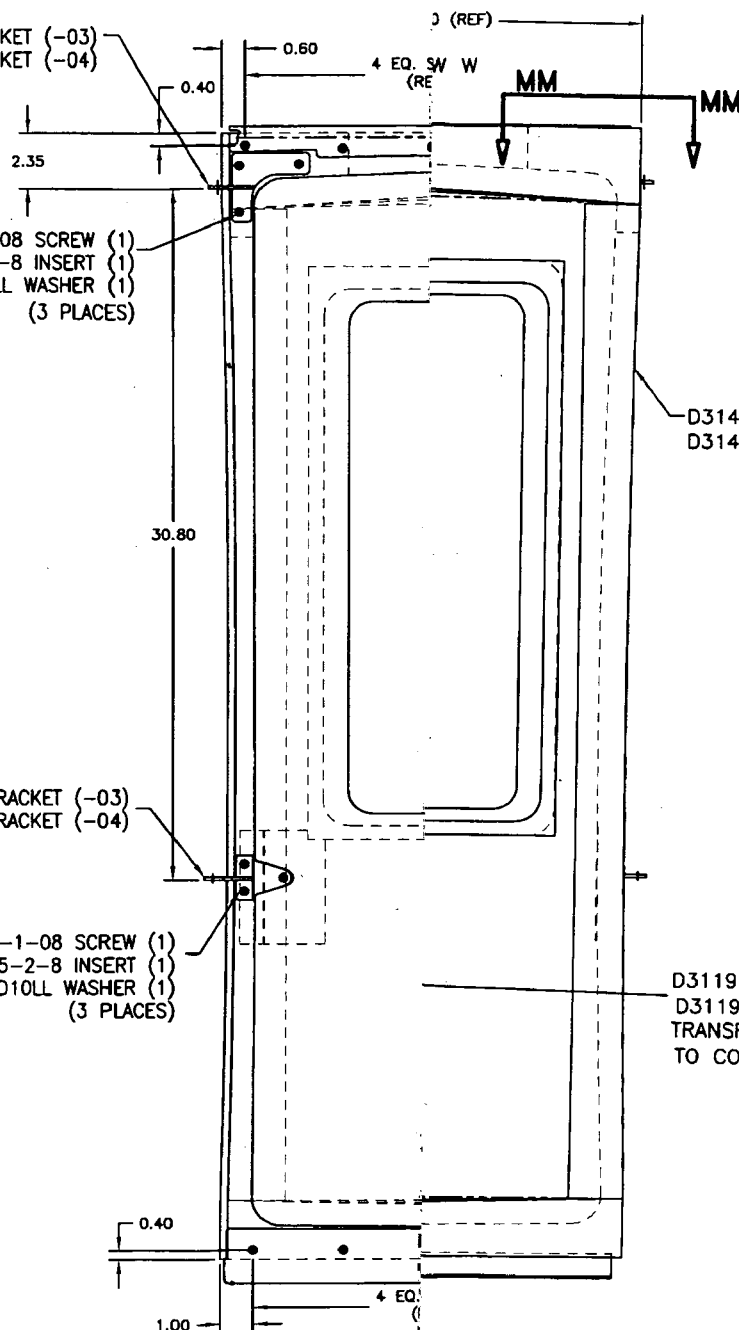
MS27039-1-08 SCREW (1)
80-005-2-8 INSERT (1)
AN960JD10LL WASHER (1)
(3 PLACES)

4

D3144-1 (REF)
D3116-5-0680 SEAL (A/R)

D3119-041/-042 (REF)

SECTION JJ-JJ



D3140-07 DOOR (-03)
D3140-08 DOOR (-04)

D3119-041 COVER ASSY (-03)
D3119-042 COVER ASSY (-04)
TRANSFER DRILL FROM DOOR
TO COVER

3

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DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

DESIGNED

DRAWING NO.
D412-694

REV. C

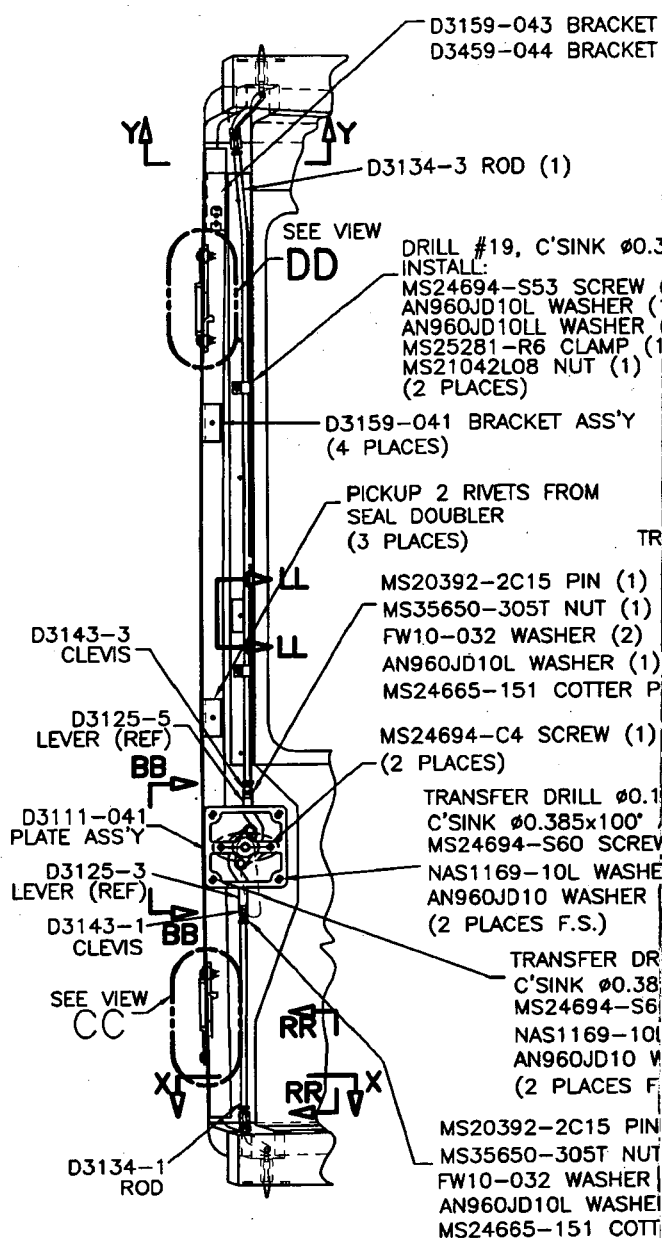
SHEET 3 OF 6

TITLE

SCALE

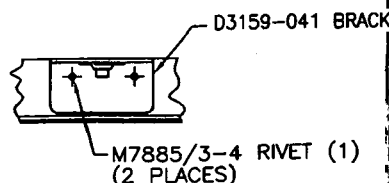
DOOR ASSEMBLY

NTS



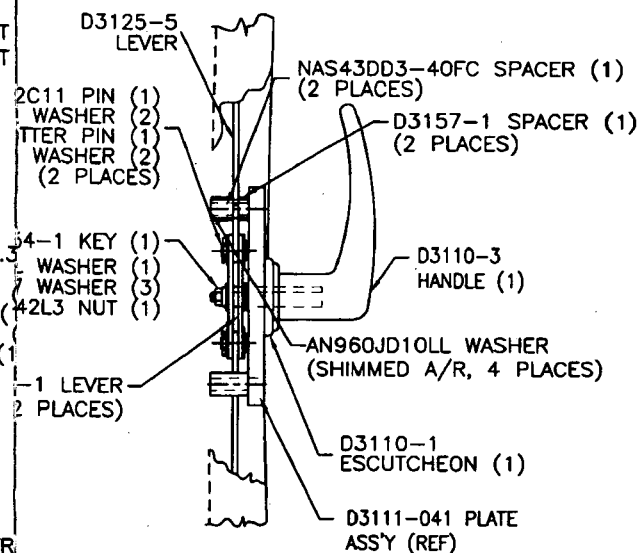
VIEW W

D3119-041/-042 COVER ASS'Y NOT SHOWN FOR CLARITY
SEAL ALSO NOT SHOWN FOR CLARITY



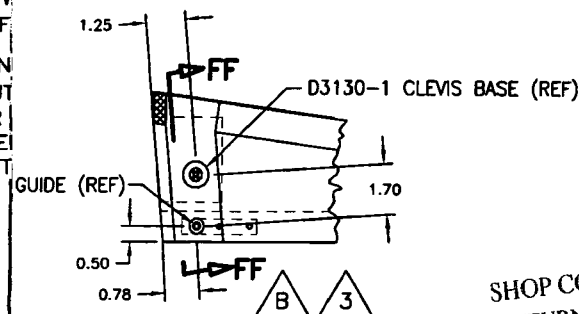
SECTION LL-LL

(3 PLACES)
VIEW ROTATED 90°CCW



SECTION BB-BB

VIEW SHOWN WITH MECHANISM
IN THE UNLOCKED POSITION
FOR CLARITY



SECTION X-X (SHOWN)

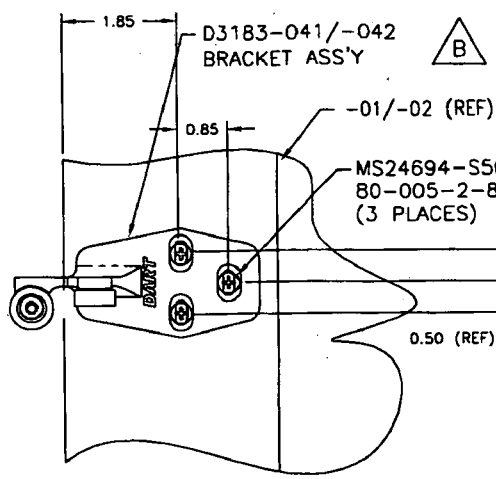
SECTION Y-Y (SIMILAR)

D3125-1 LEVER NOT SHOWN FOR CLARITY

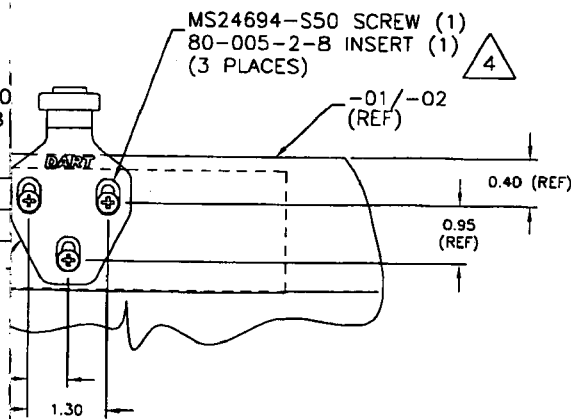
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BY	DART	DART AEROSPACE LTD.
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TITLE	DOOR ASSEMBLY	SHEET 5 OF 6
		SCALE
		NTS

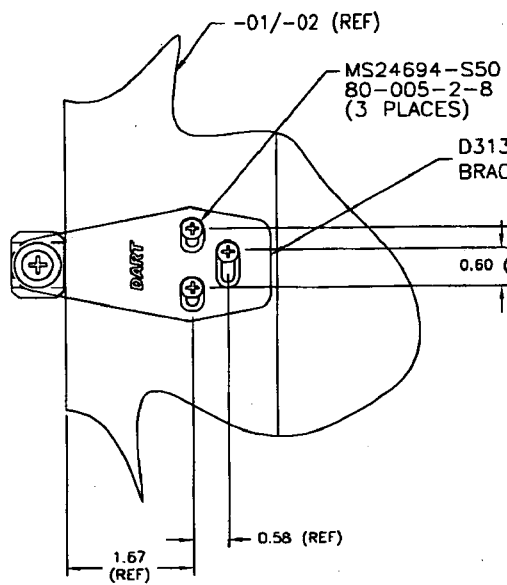
RELEASED
05/20/14



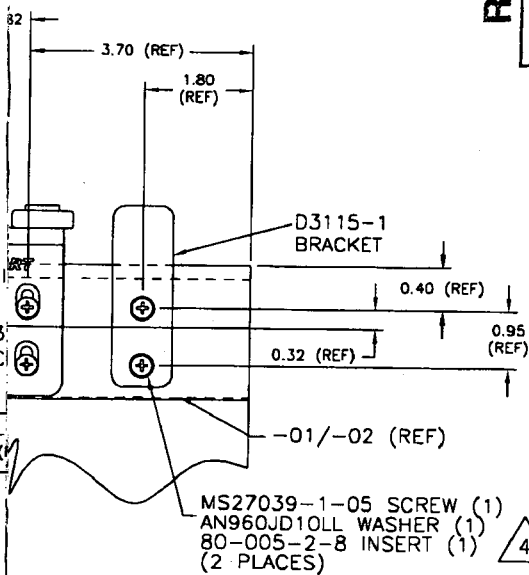
VIEW J



VIEW L



VIEW H



VIEW M

043 BRACKET ASS'Y (-01)
044 BRACKET ASS'Y (-02)



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WITHOUT NOTICE
WORK ORDER
NO. 39109A

RELEASED

05.12.01 #

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REV #	DRAWING NO. D412-694	REV. C SHEET 6 OF 6
	TITLE DOOR ASSEMBLY	SCALE NTS



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	12639
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
EPIC EXPRESS COLLECT		Point de départ		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
28/04/2008	08/06/2006	4699	C. Lavoie		PO00001429		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	DKC135-0019	D3140-06 Door Right Non Assy (Grosse) Job: 42212			
1	0	1	DKC135-0020	D3140-08 Door Right Non Assy (Petite) Job: 42212			
1	0	1	DKC135-0017	D3140-05 Door Left Non Assy (Grosse) Job: 42210			
1	0	1	DKC135-0018	D3140-07 Door Left Non Assy (Petite) Job: 42210			
<div>Revised Added work order</div>							

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department

AQ-357



Date: Jeudi, 2007-10-04 08:59:53
 Utilisateur: Marc Dubé

Feuille de Procédé

Client :	DART Dart Aerospace Ltd.	Nom Dessin :	DOOR
Numéro Job :	42210	Numéro Article :	DKC135-0008/0009
Numéro Soumission :	1725	Numéro Dessin :	D3140
Numéro B.A. :		Projet Numéro :	DKC135
Cette fois :	2007-10-04	Révision dessin :	F
Prsht Rev. :	NC	Matériel :	Tissu Fibercote E-761/7788
Prem. fois :	--	Date Dûe :	2007-10-11
Job précédente :	42209	Qté:	1 Udm: UNITE

 Écrit par : 

Vérifié & Approuvé par :

 Commentaires : N° de pièce Dart Aerospace: D3140-05/-07
 N° de pièce Delastek Aeronautique: DKA359-0008/-0009
 N° de pièce Delastek Composites: DKC135-0008/-0009

 Process Sheet Rév.: 11 Changer la révision de dessin pour la Rév.:
 F

Produit additionnel

Numéro Job:



Séq.:

Machine ou Opération:

Description :

1.0

OUTILLAGE

OUTILLAGE NÉCESSAIRE À LA FABRICATION


 Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
 OUTILLAGES NÉCESSAIRES À LA FABRICATION DE LA PIÈCE

 Moule N° B30-23000-01T
 Patron de découpe N° B30-23000-57T
 Patron de découpe N° B30-23000-61T
 Patron de découpe N° B30-23000-63T
 Patron de découpe N° B30-23000-71T
 Patron de découpe N° B30-23000-73T
 Patron de découpe N° B30-23000-75T
 Patron de découpe N° B30-23000-77T
 Patron de découpe N° B30-23000-79T
 Gabarit de taillage N° B30-23000-05T (2 pièce) et N° B30-2300-03T
 Forme de silicone N° B30-23000-07T

2.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART


 Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
 PRÉPARATION DU MOULE

Préparation du moule selon la section 5.0 de l'instruction de travail TEC-77

Quantité: 1 Date: 15-11-07 Sceau:



Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Numéro Job: 42210

Nom Dessin: DOOR

Numéro Article: DKC135-0008/-0009

Numéro Job:



Séq.:

Machine ou Opération:

Description :

3.0 AMB0211

PREPERG FIBERCOTE E761/7781 roul. 50"

Commentair Qty.: 12.3 VERGE(s)/Unit Total : 12.3 VERGE(s)
PREPERG FIBERCOTE E761/7781 roul. 50"

N° de Lot: 1-6293-1

4.0 PRÉPARATION 2

PRÉPARATION MATÉRIEL PLASTIC COMMERCIAL



Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
DÉCOUPAGE MATÉRIEL

Découpe du tissu pré-imprégné e-761 paquets de 10.5 pi². (7 paquets =24.5 Verges)

Quantité: 1 KIT Date: 16-11-07 Sceau:



5.0 DRAPAGE 1

DRAPAGE DART



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs
DRAPAGE DES PIECES

Faire le drapage de 3 plis de tissu pré-imprégné e-761 (4 Paquets) selon la section 8.1.1 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 16-11-07 Sceau:



6.0 AC0409

Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)
Tissu à délaminer Release ply B

7.0 AC0407

Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)
Wrightlon 5200 Bleu P3

8.0 AC0408

Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)
Feutre de drainage N° Airweave N 10

9.0 AC0755

Sac à vide N° Strechlon 700

Commentair Qty.: 7.770 METRE CAR(s)/Unit Total : 7.770 METRE CAR(s)
Sac à vide N° Strechlon 700

10.0 AC0098

Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 RL(s)/Unit Total : 2.0000 RL(s)
Ruban à gommer jaune #: T/AT-200Y

Date: Jeudi, 2007-10-04 08:59:53
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42210

Nom Dessin: DOOR
Numéro Article: DKC135-0008/-0009

Numéro Job:






Séq.: Machine ou Opération: Description :

11.0 POCHÉ À VIDE 1 FAIRE LA POCHÉ À VIDE



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs
EFFECTUER LA POCHÉ A VIDE

Faire le montage cuisson selon la section 8.2.1 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 16-11-07 Sceau:   




12.0 CUISSON 1 CUISSON PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
CUISSON DES PIECES

Faire la cuisson selon la section 8.3.1 de l'instruction de travail N° TEC-77

Inscrire le N° de cuisson: 5736



Quantité: 1 Date: 16-11-07 Sceau:   

13.0 DÉMOULAGE 1 DÉMOULAGE PIÈCE DART




Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
DÉMOULAGE DES PIECES

Retirez le montage cuisson et faire les retouches de la pièce, afin d'enlever les surplus de résines et les résidus de tissu à délaminer.

Quantité: 1 Date: 19-11-07 Sceau:  

14.0 INSPECTION 3 INSPECTION PIÈCE DART














Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
INSPECTION GÉNÉRALE 

Inspection de la première coquille par le département de la qualité pour s'assurer qu'il n'y aie pas de réparation à faire avant la prochaine étape.

Quantité: 1 Date: 19-11-07 Sceau:   

Date: Jeudi, 2007-10-04 08:59:53
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: DOOR	
Numéro Job: 42210		Numéro Article: DKC135-0008/-0009	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
15.0	ACP0006	Rohacell 71S 1"thick 49.2" x 98.4" plain	
Commentair Qty.: 2.00 UNITE(s)/Unit Total: 2.00 UNITE(s) Rohacell 71S 1"thick 49.2" x 98.4" plain N° de Lot: <u>1-6290-1</u>			
16.0	DÉCOUPE	DÉCOUPAGE PRIMAIRE	
			
Commentair Setup: 0.00Hrs/ Run: 360.0000Min Total Run : 6.0000Hrs DÉCOUPAGE PRIMAIRE Faire la découpe des pièces de mousse structurales (Rohacell) sur la scie à ruban selon la section 8.1.2 de l'instruction de travail N° TEC-77. Quantité: <u>1-Kit</u> Date: <u>20-11-07</u> Sceau:   			
17.0	SÉCHAGE	SÉCHAGE DU MATÉRIEL	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs SÉCHAGE DU MATÉRIEL Faire le séchage du Rohacell selon les informations du manufacturier Inscrire le N° de cuisson: <u>5737</u> Quantité: <u>1</u> Date: <u>19-11-07</u> Sceau:    <u>20-11-07</u>			
18.0	AAC0560	FILM ADHESIF PF-7035-C	
Commentair Qty.: 55 UNITE(s)/Unit Total: 55 UNITE(s) FILM ADHESIF PF-7035-C N° de Lot: <u>1-6534-1</u> <u>Exp: 15/08/2008</u>			
19.0	ACP0003	Core splice adhesive MA560.048	
Commentair Qty.: 5 UNITE(s)/Unit Total: 5 UNITE(s) Core splice adhesive MA560.048 N° de Lot: <u>1-6292-1</u>			
20.0	AAC0563	EPOCAST 87269-A/B	
Commentair Qty.: 0.25 KIT(s)/Unit Total: 0.25 KIT(s) <u>N/A</u> <u>EPOCAST 87269-A/B</u> <u>P-17</u> N° de Lot: <u>1-19854-1</u>			

Date: Jeudi, 2007-10-04 08:59:53
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42210

Nom Dessin: DOOR
Numéro Article: DKC135-0008/-0009

Numéro Job:



Séq.: Machine ou Opération: Description :

21.0 AAC0644 DOUBLER KIT D3140-5-7

Commentair Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) 1-6408-1

DOUBLER KIT D3140-5-7

1-6375-2, 1-6309-04, 1-6309-4, 1-6421-1

N° de Lot: 1-6492-2, 1-6492-3, 1-6492-1, 1-6492-4

22.0 NETTOYAGE 3 NETTOYAGE COMPOSITES DART



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

NETTOYAGE GÉNÉRALE

Faire le nettoyage des doublers selon l'instruction générale N° I.G. # Lavage pièce aluminium traité alodine.

Quantité: 1 Date: 4-04/08 Sceau:

Quantité: Date: Sceau:

23.0 ASSEMBLAGE 3 ASSEMBLAGE GÉNÉRALE DART



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run: 3.0000Hrs

ASSEMBLAGE GÉNÉRALE DES PIÈCES

Mise en place des doublers et des pièces de mousse structurales selon la section 8.1.3 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 8-10-08 Sceau:

24.0 AC0409 Tissu à délaminer Release ply B

Commentair Qty.: 4.37 VERGE(s)/Unit Total: 4.37 VERGE(s)

Tissu à délaminer Release ply B

25.0 AC0407 Wrightlon 5200 Bleu P3

Commentair Qty.: 7.18 VERGE(s)/Unit Total: 7.18 VERGE(s)

Wrightlon 5200 Bleu P3

26.0 AC0408 Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total: 6.00 VERGE(s)

Feutre de drainage N° Airweave N 10

27.0 AC0755 Sac à vide N° Strechlon 700

Commentair Qty.: 7.770 METRE CAR(s)/Unit Total: 7.770 METRE CAR(s)

Sac à vide N° Strechlon 700
















28.0 AC0098 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.0000 RL(s)/Unit Total: 2.0000 RL(s)

Ruban à gommer jaune #: T/AT-200Y

Date: Jeudi, 2007-10-04 08:59:53
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.		Nom Dessin: DOOR	
Numéro Job: 42210		Numéro Article: DKC135-0008/-0009	
Numéro Job:			
# Séq.:	Machine ou Opération:	Description :	
29.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE	
			
Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs EFFECTUER LA POCHE A VIDE Faire le montage cuisson selon la section 8.2.2 de l'instruction de travail N° TEC-77 Quantité: <u>1</u> Date: <u>8/10/08</u> Sceau: 			
30.0	CUISSON 1	CUISSON PIÈCE DART	
			
Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs CUISSON DES PIECES Faire la cuisson des pièces selon la section 8.3.2 de l'instruction de travail N° TEC-77 5770 Quantité: <u>1</u> Date: <u>8/10/08</u> Sceau: 			
31.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART	
			
Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs DÉMOULAGE DES PIECES Retirez le montage cuisson de sur la pièce, et enlever les résidus de ruban adhésif en teflon et les barres d'aluminium, Garder seulement la barre qui sépare les deux pièces. Quantité: <u>1</u> Date: <u>4/10/08</u> Sceau: 			
32.0	DÉCOUPE CORE	DÉCOUPE DU CORE DART	
			
Commentair Setup: 0.00Hrs/ Run: 210.0000Min Total Run : 3.5000Hrs USINAGE DES MOUSSE Usinage des mousses sturcturales selon la section 8.1.4 de l'instruction de travail N° TEC-77 Quantité: <u>1</u> Date: <u>4/10/08</u> Sceau: 			
33.0	INSPECTION 3	INSPECTION PIÈCE DART	
			
Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs INSPECTION GÉNÉRALE Faire la vérification de l'usinage intérieur pour s'assurer que tout soit conforme au dessin avant la prochaine étape.			

Date: Jeudi, 2007-10-04 08:59:53
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42210

Numéro Article: DKC135-0008/-0009

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
34.0	AMB0211	PREPERG FIBERCOTE E761/7781 roul. 50"

Commentair Qty.: 12.3 VERGE(s)/Unit Total : 12.3 VERGE(s)
PREPERG FIBERCOTE E761/7781 roul. 50"

N° de Lot: 1-20139-1

35.0	DRAPAGE 1	DRAPAGE DART
------	-----------	--------------



Commentair Setup: 0.00Hrs/ Run: 180.0000Min Total Run : 3.0000Hrs
DRAPAGE DES PIECES

Drapage de la coquille intérieur selon la section 8.1.5 de l'instruction de travail N° TEC-77

Quantité: 1 Date: 5/4/08 Sceau: 23



36.0	AC0409	Tissu à délaminer Release ply B
------	--------	---------------------------------

Commentair Qty.: 4.37 VERGE(s)/Unit Total : 4.37 VERGE(s)
Tissu à délaminer Release ply B

37.0	AC0407	Wrightlon 5200 Bleu P3
------	--------	------------------------

Commentair Qty.: 7.18 VERGE(s)/Unit Total : 7.18 VERGE(s)
Wrightlon 5200 Bleu P3

38.0	AC0408	Feutre de drainage N° Airweave N 10
------	--------	-------------------------------------

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)
Feutre de drainage N° Airweave N 10

39.0	AC0755	Sac à vide N° Stretchlon 700
------	--------	------------------------------

Commentair Qty.: 7.770 METRE CAR(s)/Unit Total : 7.770 METRE CAR(s)
Sac à vide N° Stretchlon 700

40.0	AC0098	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Commentair Qty.: 2.0000 RL(s)/Unit Total : 2.0000 RL(s)
Ruban à gommer jaune #: T/AT-200Y

41.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE
------	----------------	-----------------------



Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs
EFFECTUER LA POCHE A VIDE

Faire le montage cuisson selon la section 8.2.3 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 5/4/08 Sceau: 23



Date: Jeudi, 2007-10-04 08:59:53
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 42210

Nom Dessin: DOOR
Numéro Article: DKC135-0008/-0009

Numéro Job:



Séq.: Machine ou Opération: Description :

42.0 CUISSON:1 CUISSON PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
CUISSON DES PIECES

Faire la cuisson de la pièce selon la section 8.3.3 de l'instruction de travail N° TEC-77.

5807

Quantité: 1 Date: 5/04/08 Sceau:

43.0 DÉMOLAGE 1 DÉMOLAGE PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
DÉMOLAGE DES PIECES

Retirez le montage cuisson, et faire de retouches sur la pièce afin d'enlever les surplus de résine et les résidus de tissu à délaminer.

Retirer la pièce du moule.

Quantité: 1 Date: 7/04/08 Sceau:

44.0 TRIMAGE 3 TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
TRIMAGE DE FINITION

Faire le trimage de finition de la pièce selon la section 8.5 de l'instruction de travail N° TEC-77.

Quantité: 1 Date: 10/04/08 Sceau:

45.0 AAC0671 Dupont Primer N° 1104S

77045

Commentaire Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-6473-2

46.0 AAC0670 Dupont Activator N° 7975S

77755

Commentaire Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)
Dupont Activator N° 7975S N° de Lot: 1-6473-1

47.0 AAC0672 Dupont Reducer N° 12375S

Commentaire Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: N/A

Date: Jeudi, 2007-10-04 08:59:53

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42210

Numéro Article: DKC135-0008/-0009

Numéro Job:



Séq.: Machine ou Opération: Description :

48.0

PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentaire Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs

PRÉPARATION DU MATÉRIEL

APR 16 2008



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabricant.

49.0

INSPECTION 3

INSPECTION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

INSPECTION PIÈCE DART

Faire l'inspection par le département de la qualité "Tap test et inspection dimensionnel "

Date: 16-4-08

Sceau:



Initiales:

N.S.

50.0

PEINT/ PRIMER2

PEINTURE / PRIMER DART



Commentaire Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

APPLICATION DE PRIMER

Appliquer une épaisse couche de primer partout sur les deux portes.

Quantité: 1

Date: APR 16 2008

Sceau:



51.0

FINITION 3

FINITION PIÈCE DART



Commentaire Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs

FINITION GÉNÉRALE

Faire un sablage léger (Grit 320-400) de toute les surfaces.

Quantité: 1

Date: 21-04-08

Sceau:



52.0

AAC0671

Dupont Primer N° 1104S

7704S

Commentaire Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)

Dupont Primer N° 1104S

N° de Lot: 1-6473-2

53.0

AAC0670

Dupont Activation N° 7975S

7775S

Commentaire Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)

Dupont Activation N° 7975S

N° de Lot: 1-6473-1

Date: Jeudi, 2007-10-04 08:59:53

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.

Nom Dessin: DOOR

Numéro Job: 42210

Numéro Article: DKC135-0008/-0009

Numéro Job:



Séq.: Machine ou Opération: Description :

54.0 AAC0672 Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total: 0.1250 GALLON(s)

Dupont Reducer N° 12375S

N° de Lot: N/A

55.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
PRÉPARATION DU MATÉRIEL

APR 24 2008



Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

56.0 PEINT/ PRIMER2 PEINTURE / PRIMER DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
APPLICATION DE PRIMER

Application d'une couche de primer de finition partout sur les deux portes.

Quantité: 1

Date: APR 24 2008

Sceau:



57.0 IDENTIFICATION4 IDENTIFICATION PIÈCES DART



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
IDENTIFICATION DES PIÈCES

Identifier le numéro de la pièce, le numéro de job ainsi que la date de fabrication sur l'aluminium peinturé dans le dégagement des mécanisme de porte.

Grosse porte : D3140-05

Petite Porte: D3140-07

Quantité: 1

Date: APR 24 2008

Sceau:

24/04/08



58.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
INSPECTION GÉNÉRALE

Inspection finale par le département de la qualité selon le dessin D3140.

Date: 25-4-08

Sceau:





Initiales: P.S.

Date: Jeudi, 2007-10-04 08:59:53
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART	Dart Aerospace Ltd.	Nom Dessin: DOOR
Numéro Job: 42210		Numéro Article: DKC135-0008/-0009

Numéro Job: 

# Séq.:	Machine ou Opération:	Description :
59.0	EMBALLAGE 3 	EMBALLAGE PIÈCE DART 

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
EMBALLAGE ET ENTREPOSAGE

Faire l'emballage selon la section 8.7 de l'instruction de travail N° TEC-77

Quantité: 1 Date 25-04-08 Sceau: 